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RB23007615
Job Sheet 201719



Part No: RB23007615

Job Qty: 1 pcs

DAS
21
9-89

Part Name: Power Turbine Support Cleaning C-30 & C-47



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/9/19

Job Tracking No:

Due Date: 11/6/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RB23007615 REV B IPP REV A 18.02.20 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	11/6/19		0.00	1.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		GP19-10-22
							Small Fab - 7		
							Small Fab - 8		
110	QC 5	1 pcs	11/6/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		OCT 22 2019
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	11/6/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		

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				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	DAS
				Packaging 3 - 8 - B4B	28
				Packaging 3 - 9 - B4B	9-89
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	11/6/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

Part Op 100 - Small Fab-9 (Small Fab) 1- Assemble as per DWG RB23007615 3- ***NOTE Red Barn sticker on sheet #7 N/A as Descriptions: per Eng.

110 - QC5 (QC5- Inspect part completeness to step on W/O)

130 - Packaging3-2 (Identify as per dwg & Stock Location: _____) Identify and Stock

140 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
K206	Flambeau Plastic Box (Clean Out)	1 Ea (1 ea)	100-Small Fab - 1	167655
PAD210	Foam Ø1 X 1 replace item 1887T48	.2220 sf (.222 ea)	100-Small Fab - 1	021550
RB23007615-11	#12 Drill Bit	1 pcs (1 ea)	100-Small Fab - 1	160914
RB23007615-13	Saw	1 pcs (1 ea)	100-Small Fab - 1	125907x6 156856
RB23007615-15	Wire	4 ft (4 ea)	100-Small Fab - 1	097885
RB23007615-21	Guide	1 pcs (1 ea)	100-Small Fab - 1	141679
RB23007615-23	Socket Head Cap Screw	3 pcs (3 ea)	100-Small Fab - 1	144310
RB23007615-25	Strut Checking Gauge	1 pcs (1 ea)	100-Small Fab - 1	150287
RB23007615-3	#56 Drill Bit	1 pcs (1 ea)	100-Small Fab - 1	160412
RB23007615-5	#52 Drill Bit	1 pcs (1 ea)	100-Small Fab - 1	160916
RB23007615-7	#27 Drill Bit	1 pcs (1 ea)	100-Small Fab - 1	147737
RB23007615-9	#22 Drill Bit	1 pcs (1 ea)	100-Small Fab - 1	204171

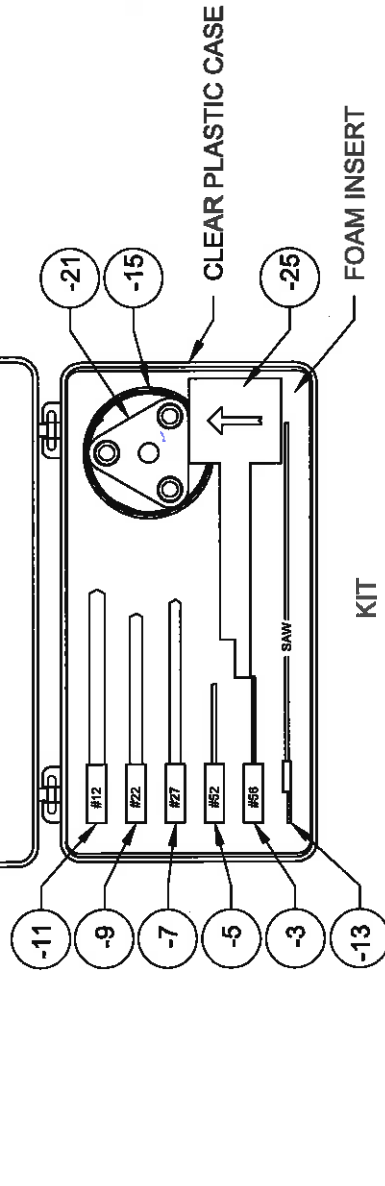
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	K206	1	52	0
	PAD210	0	9	0
	RB23007615-11	1	13	0
	RB23007615-13	1	16	0
	RB23007615-15	4	130	0
	RB23007615-21	1	10	0
	RB23007615-23	3	42	0
	RB23007615-25	1	13	0
	RB23007615-3	1	12	0
	RB23007615-5	1	12	0
	RB23007615-7	1	32	0
	RB23007615-9	1	14	0
Part Specifications				
Specifications could not be found.				

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
A	CHD TITLEBLOCK & REVISION BLOCK. ADDED DWG'S FOR CASE, FOAM INSERT, & ASSY.	5/11/09	RJC
B	-2 ADDED NOTES TO SHEET. -13, -21, -23 MOVED TO SEPARATE SHEETS. -13 CHD DIMS WAS 6.000 IS 6.00, WAS 12.000 IS 12.00. -21 CHD DIMS WAS R.300 X3 IS 3X R.30, WAS DRILL & TAP 1/4-28 UNF X3 IS 3X 1/4-28 THRU. ADDED MISSING DIM 2X .344.	2/3/14	DPD
			RJC

TEO ATTACHED



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WITHOUT NOTICE
WORK ORDER
NO. 201719 HCS
19-10-09

ASSY QTY	BIO	PART #	UNIT QTY	DESCRIPTION	MATERIAL	BIO INFORMATION OR SPECIFICATIONS	Pg.
		-2	5	BLOCK	6061	5/16 HEX x 1	2
		-3	1	#56 DRILL BIT		SEE -2 -56 FOR BLOCK METHODS	2
		-5	1	#52 DRILL BIT		SEE -2 -52 FOR BLOCK METHODS	2
		-7	1	#27 DRILL BIT		SEE -2 -27 FOR BLOCK METHODS	2
		-9	1	#22 DRILL BIT		SEE -2 -22 FOR BLOCK METHODS	2
		-11	1	#12 DRILL BIT		SEE -2 -12 FOR BLOCK METHODS	2
		-13	1	SAW		6" LENGTH #HAC5012BX (BESTWAY PRODUCTS)	3
		-15	4'	WIRE		.050 ROUND x 6 SECTION	
		-21	1	GUIDE	6061	.041 WRAPPED AROUND 1-7/8 ARBOR	1
		-23	3	SOCKET HEAD CAP SCREWS	STEEL	Ø2 x 1-1/16	4
		-25	1	STRUT CHECKING GAGE	6061	1/4-28 UNF x 3/8 MODIFIED MCMASTER-CARR #61251A435	5
			1	CLEAR PLASTIC CASE		.05 x 4-7/8 x 1-1/2	6
			1	CRAFT FOAM		FLAMBEAU #K206 OR EQUIV.	7
			1	RED BARN STICKER		1 x 4 x 8	7
			1			STICKER FACE INSIDE LID FACING OUT	7

RED BARN MACHINE

POWER TURBINE CLEANING KIT

DWG NO. RB23007615 REV B

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED	DATE	INITIAL
TOLERANCES ON:	CLOUGH		
XXX ± .005			
XX ± .01			
X ± .01			
FRACTIONS ± 1/32			
ANGLES ± 5°			
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
USED ON MODEL			
ALLISON C30			

SCALE 1:3 DATE 2-1-01 SHEET 1 of 7

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ Scrap ☐ ☐ Use-as-is ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐				Date : _____ Sequence #: _____ QTY Affected : _____		MRB (QS1042) _____	
Description Work Order Deviation				Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY <table style="width: 100%;"> <tr> <td style="width: 33%;"> Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ </td> <td style="width: 33%;"> Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ </td> <td style="width: 33%;"> Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ </td> </tr> </table> Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	
Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐									
Other/Details: _____				Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____							